Work Order ID 124482 September-11-14 12:07:09 PM				*124			***************************************		Page 1			
Item ID: D353 Revision ID: Item Name: Space		1		*N900040100*				<b>7*</b> s	Setup S	Start Stop		S1* S2*
Start Date: Required Date Reference:	9/10/14 • 9/10/14	Start Qty: 20.00 Req'd Qty: 20.00	7 1 1		Cust Item I Customer:	D:					ı VI,	17
Approvals:	Process	s Plan: MUゴ	Date: 14-09-16		D:	ate:		F	Run Start		*N	R1*
	QC:_		Date:		Da	Date:				Stop	*NI	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr			" (							
D3532		Rev A										
*100 Hardinge  Hardinge CNC Lath	ne Small	Hardinge CNC LATHE  Memo  1-TURN A REV: 1	E SMALL  AS PER FOLIO FA643 & DWO  M_DWG REV:A2-1	0.00  0.00  G D3532 ,FOLIO	0			_20		g		/1st 10/10
110 <b>*110*</b> QC Quality Control		QC2- Inspect parts off		0.00				20_	<i>J</i>	r		/14/10/10
120 *1 20* QC Quality Control		QC8- Inspect parts - sec	cond check	0.00				20	Ø			DAS 40 9-89 H/10/10

DQA: Date:					- WORK ORDER NON-CONFORMANCE / UPDATE							
		Date:								ork Order up	date only	72
r:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Part No				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
				Desc	ription of work order update			Actio	on	Sign &		
	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n QC Inspector
		<u> </u>				FAI	ULT CAT	ΓEGORY				
ng G	iear				General	rai		- 102 - 10 TO		<b>-</b>		
Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Unspection Strip in Tube Marks/Chatter Turning Sequence BOM/R Broken, Burrs Contami Counte Cut Too Drawin			BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalia Mislaba Misread Off-set	are ion Incomplete/Un tions Incomplete/U gned/off center eled d	<u> </u>	Over/Under Part Incorre Part Lost/M Part Moved Positioned V	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	o	O	Date:  r:  O.  Date Step  Date Step	Date:  T:	Date:  T:	Date:    Disposition   Rework   Scrap   Use-as-is   Suspected Unapproved	Date:   DISPOSITION   Rework   Scrap   Use-as-is   Suspected Unapproved   Suspected Unapp	Pault CAT    Control   Con	WORK ORDER NON-CONFORMANCE / UP  Date:  DISPOSITION  Rework   Scrap   Use-as-is   Use-as-is   Large Fab   Large Fa	Date   Description   Descrip	Date:    Disposition   Rework   Scrap   Use-as-is   Suspected Unapproved   Use-as-is   Large Fab   Composite   Proposite   Date   Step   Qty   Description of work order update   Initial   Action   Composite   Date   Composite   Date   Composite   Composite	Date   Disposition   Rework   Scrap   Use-as-is   Suspected Unapproved   Date   Step   Qty   Description of work order update   Initial   Action   Date   Step   Qty   Description of work order update   Initial   Action   Date   Date   Step   Qty   Description of work order update   Initial   Action   Description   Date   Verification   Date   Verification   Date   Verification   Date   Verification   Date   Da

Work Ord September-11-1				*124				Page 2			
Item ID: Revision ID: Item Name:	D3532-1 Spacer			Accept	*N900040	)1 <b>(</b> (	1		Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	9/10/14 : 9/10/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:					"IV.	· ·
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):	Date:			Run	Start Stop	^I\	R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: Stous	Set Up/ Run Hours 0.00	Tool ID Tool #	# Plan Code	Accept Qty	Re		Reject Number	Insp. Stamp
140 <b>*1 4 1 *</b> QC Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00					ľ	1/10	15 9 MF 14-10-

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							`DART	
QA Closed:			Date:			WORK ORDER NON-	-((	JNFOI	RIVIANCE / U		Wo	ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS	
Work Orde	er: _						1		<b>-</b>	¬				
							Rework		Skid-tube	Crosstube		Water Jet		Engineering
Part N	10.					Scrap Use-as-is			Machining noforming	Small Fab Finishing	$\dashv$		d. Eng. Coor. re/Packaging	Quality Other
NCR N	NCR No.			Suspected Unapproved			Large Fab	Composite		Nec/3tol	Supplier			
TTCIT I	••••					Suspected Griapproved								
Root					Desci	ription of work order update	İ	nitial	Act	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design													1	
Doc/Data														
Equip/Tooling										•				
Handling/Pre														
Material		, A												
Operator		1					l							
Offset/Setup							ŀ							
Process														
Supplier														
Training														
Transport								-						
Unapproved														
							FA	ULT CA	regory					
Landi	ng (	Gear			_	General		7		,		1	<u></u>	<del>_</del>
		Bending				Bend	L	-	Program			Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u></u>	Grain				Over/Under		Set-up
	L	Cracks				Broken/Damage/Defect		Hardwa	ire	,	_	Part Incorre	<b>⊢</b>	Temperature/Cure
	L	Crimp/Kir	nk/Ripple	/Wave		Burrs	_	Inspect	ion Incomplete/U	nqualified	_	Part Lost/Mi	ssing	Weld
<i>'</i>		Cuffs			<u> </u>	Contamination	<u></u>		tions Incomplete/	Unclear	$\vdash$	Part Moved	L	Wrong Stock Pulled
	Crushing Countersink		Countersink		- 1	ned/off center	!		Positioned V	· -	_			
	Heat Treat Cut Too Short			<u></u>	Mislabe			<u> </u>	Power Loss/	Surge	Other			
	Inspection Strip in Tube Drawing				Misrea									
	Marks/Chatter Drill Holes			Drill Holes	Off-set									
		Turning S	equence			Finish	Out of Calibration							
	Wave/Twist in Tube Fit/Function				Fit/Function	$\perp$	Out of	Sequence						

**Picklist Print** 

September-11-14 12:07:09 PM

Work Order ID: 124482

\*124482\*

Parent Item:

D3532-1

\*D3532-1\*

Parent Item Name: Spacer

**Start Date:** 9/10/14

Required Date: 9/10/14

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP Rev:A New Issue 06-07-12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No				f	34.6727		1	<del></del>		. ,
*MDFIRII Delrin Round Bar 0.75" col		)*							**			/ - /	10/10
				Location		Loc (	<u>Oty</u>	Loc Code					
				MAT039		34.6	5727						
					m127442	24.3	3977		_				
				1	m129148	10.	.275			1 49'	-		

DQA: Date:			WORK ORDER NON-		NIE () E	RMANCE / HPDATE				DART			
QA Closed:			Date:			WORK ORDER NOW		NITOI	WAREL OF BATE	W	ork Order up	date only	AEROSPACE
Work Orde	·					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Part No.				Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other		
NCR N	10			<u>-</u>		Suspected Unapproved Large Fab Composite				Supplier			
Root	Root Des			Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance Chief Eng Description			Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA	TEGORY				
Landi	ng G	Gear		-		General		-					
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence  Bom/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish				Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	tion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
					Out of	Out of Sequence							

DART AEROSPACE LTD	Work Order:	124482
Description: Spacer	Part Number:	D3532-1
Inspection Dwg: D3532 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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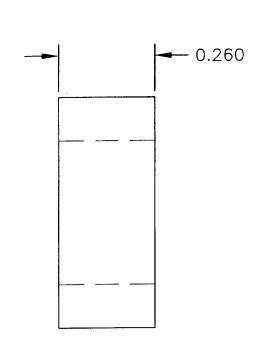
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.622			MJD-04	vern
Ø0.391	+0.006/-0.001	0 393	V		,,,	, , ,
0.260	+/-0.010	0,622			i 1 1	, , ,
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						400
			DAS			

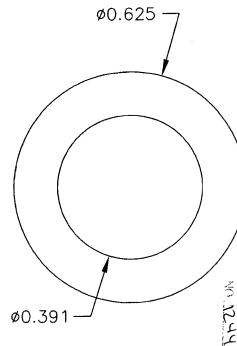
Measured by:	MISP	Audited by:	9-89	Prototype Approval:	N/A
Date:	14/10/10	Date:	H/10/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.09	New Issue	KJ/EC/DD -	B
	-		· (1	_



DESIGN PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECKED	APPROVED	DRAWING NO.		REV. A
#	-	D3532		SHEET 1 OF 1
DATE		TITLE		SCALE
06.06.26		SPACER		4:1
Α	06.06.26	NEW ISSUI	E	





D3532-1 SPACER

D3532-1 SPACER

DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD) MATERIAL: 1)

2) FINISH:

NONE 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)

ALL DIMENSIONS ARE IN INCHES



UNCONTROLLED COPY SUBJECT TO AMENDMENT **JOHN LIGHTIM** 

ENGINEERING

Adon aons

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